

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023127**Date Inspected:** 10-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13AE, 14W**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding(SMAW), and Flux Cored Arc Welding(FCAW) process.

ZPMC QC is identified as Zheng Zhi Wei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: I Rib Stiffener

PCMK: SEG3020AH

Weld Number: 014

Welder: 066674

WPS-B-P-2212-TC-U4b-FCM-1

Component: Side Plate I Rib

PCMK: SEG3020AL

Weld Number: 031, 039

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder: 067611
WPS-345-SMAW-3G-FCM-Repair-1
CWR-2909

Component: Edge Plate
PCMK: SEG3020AG
Weld Number: 008
Welder: 066398
WPS-345-SMAW-2G-FCM-Repair-1
WR-20412

Trial Assembly Yard

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding(SMAW), and Flux Cored Arc Welding(FCAW) process.
ZPMC QC is identified as Zhan Hai Feng.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

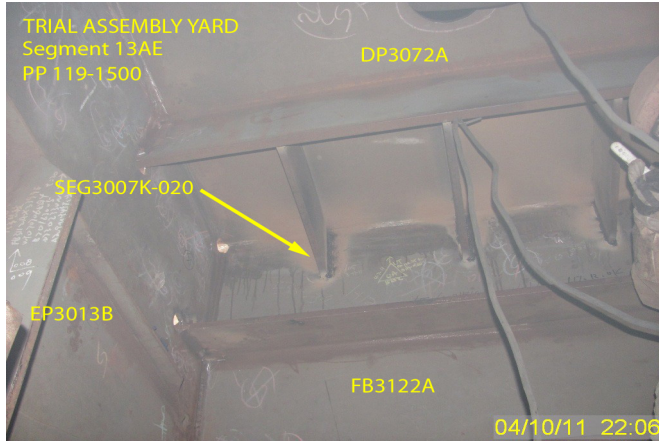
Component: I Rib Stiffener
PCMK: SEG3020AP
Weld Number: 030, 034
Welder: 215553
WPS-B-P-2213-TC-U4b-FCM-1
WR-20412

Component: I Rib Stiffener
PCMK: SEG3007K
Weld Number: 014, 020
Welder: 216086
WPS-B-T-4113-TC-U4b-2

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
